Work Order ID 114762

March-11-14 4:12:37 PM

114762

Item ID: D4634-5
Revision ID:
Item Name: Aft, Center Ceiling Panel
Start Date: 12/03/2014 **Start Qty:** 1.00 *1*
Required Date: 12/03/2014 **Req'd Qty:** 1.00 *1*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** MLS **Date:** 14-03-12 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Draw Nbr	Revision Nbr
D4634	F

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	HAND FINISHING THERMOFORMING	0.00							DAS 07 9-89
100		0.00				X1	____	____	14/04/01
Thermoform	**Memo**								
Thermoforming Machine	Cut Blanks								
105	Dry Material	0.00							DAS 07 9-89
105		0.00				X1	____	____	14/04/01
HandThermo	**Memo**								
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								

Temp: ~~245 deg. F~~
Time IN: 5:00 PM
Time OUT: 6:00 AM

APR 0 1 2014

By:

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Work Order ID 114762

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Revision ID:
Item Name: Aft, Center Ceiling Panel
Start Date: 12/03/2014 **Start Qty:** 1.00 *1*
Required Date: 12/03/2014 **Req'd Qty:** 1.00 *1*
Reference:

Accept *N9000040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							DAS 07 9-89
110	THERMOFORMING MACHINE					X1	____	____	14/04/01
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4634-5 and Folio FTA146								
	Dwg. Rev. F								
	Folio Rev. D								
	Visually inspect for proper formation and texture								
130		0.00							
130	HAND FINISHING THERMOFORMING					X1	BB	____	14/05/14
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
140	QC6- Inspect dimensions to drawing	0.00 SHP							
140	Dimensional Inspection								
QC	**Memo**	0.00 4/5/14							
Quality Control	Fill out Inspection Sheet Rev A								

DQA: _____ Date: _____

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DART AEROSPACE

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Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150 QC Quality Control	**Memo** N/A	0.00				SMP 14/5/14			
160	Packaging	0.00							
160 Packaging Packaging	**Memo** Section MF	0.00				(1)	SAD 14/05/13		
170	QC21- Final Inspection - Work Order Release	0.00							
170 QC Quality Control	**Memo**	0.00				MLS	14-05-14		

14-05-14

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☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

March-11-14 4:15:22 PM

1 / 1

Work Order ID: 114762 *114762*

Parent Item: D4634-5 *D4634-5*

Parent Item Name: Aft, Center Ceiling Panel

Start Date: 12/03/2014 **Required Date:** 12/03/2014

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 13/07/09 DL verf:DD IPP Rev C Dwg. Update, Material Change 13/12/18 DL IPP Rev. D 14/01/20 Dwg Update DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	840.7600	17.33 **	18			

MLEXS.093-F6006-07

GE PLASTICS LEXAN SHEET

DL 14/05/07

Location	Loc Qty	Loc Code
MAT023	840.76	
114459	229.26	
123105	38	
124501	573.5	

128668

18 sq ft

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

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Transport	☐									
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☐ Turning Sequence
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General

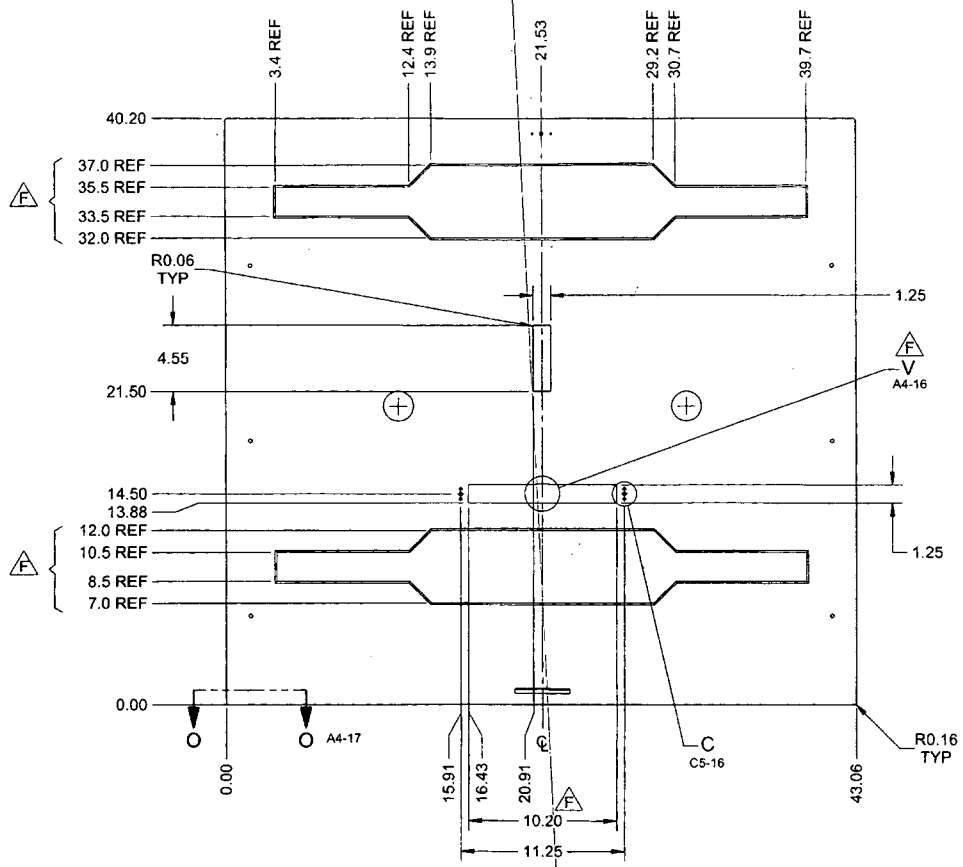
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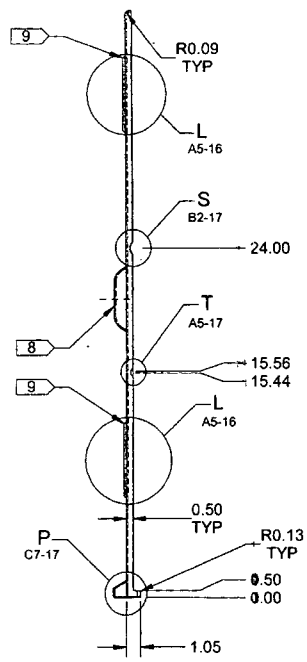
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☐ Other





114762 MLS
1403-12

NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 7.39 lbs
8) TEXTURE ON THIS SIDE
9) 0.14 RADIUS NOT SHOWN FOR CLARITY
10) DRILL & TRIM D4634-5 PER TOOL DT9838
11) THERMOFORM PER QSI 022 USING DT9846 TOOL
MIN. THICKNESS AFTER FORMING:
EDGES = 0.060
ELSEWHERE = 0.070
12) LOCATE Ø2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-5 AFT, CENTER CEILING PANEL

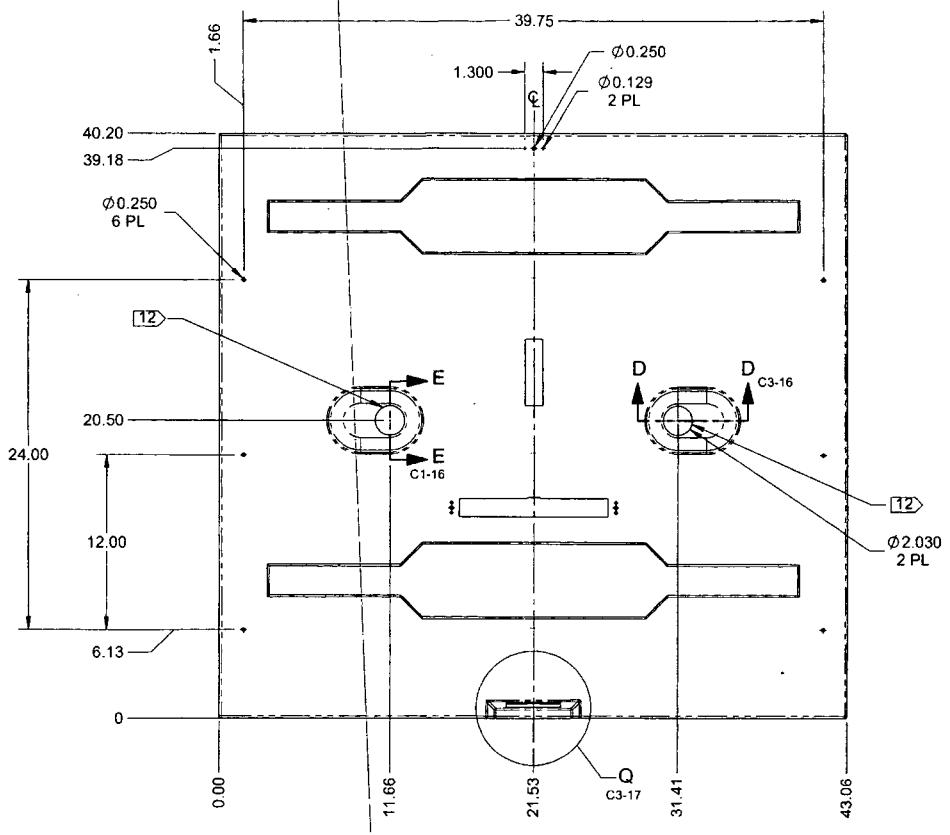
RELEASED
2014 FEB 25

DESIGN	RF
DRAWN	RF
CHECKED	DC
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	14.02.03

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4634 REV. F
SHEET 14 OF 17
TITLE CENTER CEILING PANELS SCALE NTS

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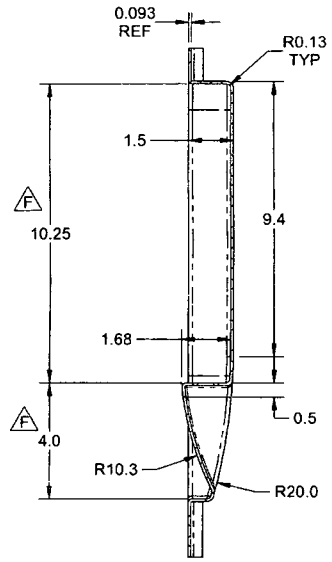


D4634-5 AFT. CENTER CEILING PANEL
AUXILIARY VIEW

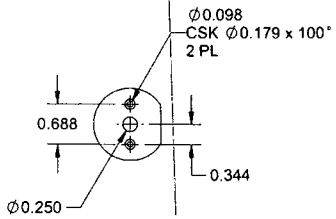
RELEASED
2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD**
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	DC	DRAWING NO. D4634 REV. F
MFG. APPR.		SHEET 15 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE 14.02.03		

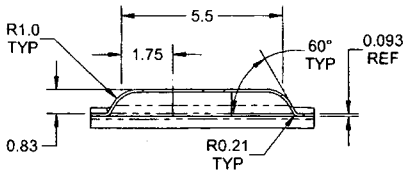
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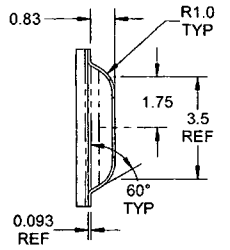
SECTION G-G C5-11
SCALE 4X



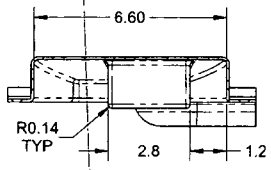
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SCALE 4X



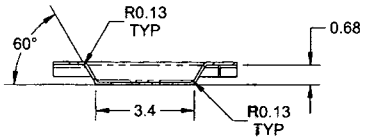
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SCALE 2X



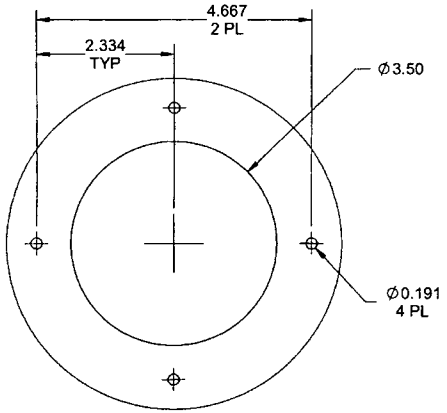
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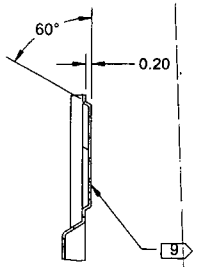
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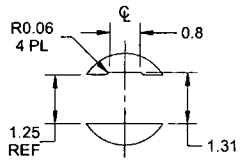
SECTION J-J B6-13
SCALE 2X



DETAIL B B7-10
SCALE 4X
2 PL



DETAIL L B2-13 C2-13 B2-14 C2-14
SCALE 4X
TYP

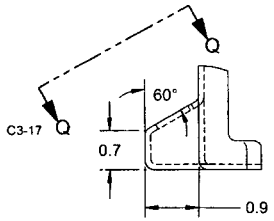


F DETAIL V C4-10 B4-12 C4-14
SCALE 2X
SIMILAR

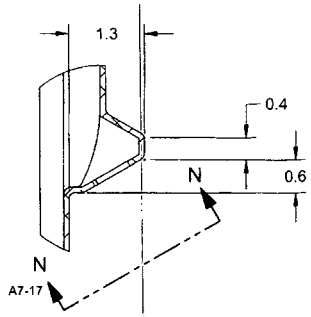
RELEASED
2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4634 REV. F
CHECKED	DC	SHEET 16 OF 17
MFG. APPR.		TITLE CENTER CEILING PANELS SCALE NTS
APPROVED		
DE APPR.		
DATE	14.02.03	

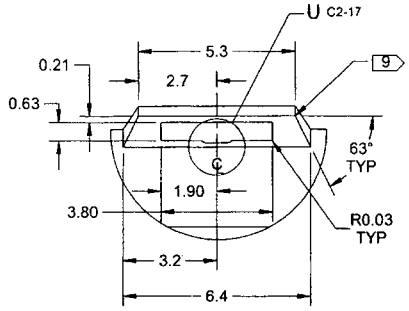
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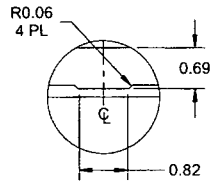
DETAIL P B3-14
SCALE 2X



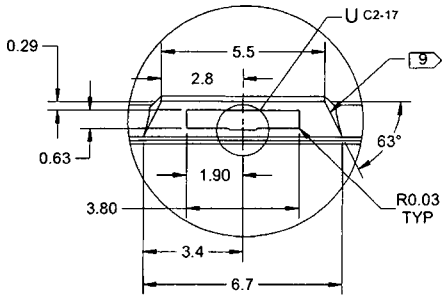
DETAIL M C3-10
SCALE 2X



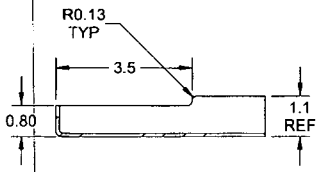
DETAIL Q B4-15 D8-17
SCALE 0.5X



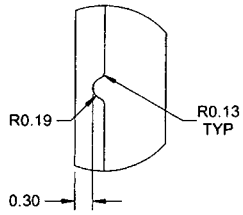
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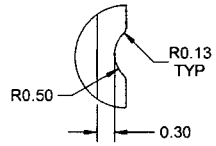
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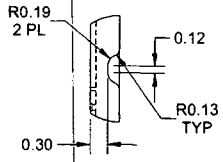
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10 C3-10 B2-12
SCALE 4X



DETAIL S B3-10 C2-12
SCALE 4X



DETAIL T C2-14
SCALE 4X

RELEASED
2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4634 REV. F
MFG. APPR.		SHEET 17 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.02.03	

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DART AEROSPACE LTD

Description: Aft Center Ceiling Panel		**Work Order:** 114762	
Inspection Drawing: 4634-5	**Rev:** F	**Part Number:** D4634-5	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.20	±0.030	10.20			tape	SFAB-21
11.25	±0.030	11.25			"	
15.91	±0.030	15.910			"	
1.25	±0.030	1.260			vern	SFAB-08
4.55	±0.030	4.553			"	
21.50	±0.030	21.500			tape	SFAB-21
13.88	±0.030	13.750			"	
1.25	±0.030	1.250			vern	SFAB-06
21.53	±0.030	21.500			tape	SFAB-21
12.00	±0.030	12.00			"	
24.00	±0.030	24.00			"	
20.50	±0.030	20.506			"	
Ø 0.250	+0.005 -0.001	.250			vern	SFAB-08
39.75	±0.030	39.75			tape	SFAB-21
1.300	±0.010	1.300			vern	SFAB-06
Ø 0.129	+0.005 -0.001	.128			"	
Ø 0.250	+0.005 -0.001	.250			"	
11.66	±0.030	11.676			tape	SFAB-21
31.41	±0.030	31.411			"	
Ø 2.030	+0.012 -0.001	2.039			vern	SFAB-08
3.80	±0.030	3.780			"	
0.63	±0.030	.620			"	

Measured by: [illegible]	**Checked By:** SMP	**QC inspector:** SMP	**Engineering Approval** *(if necessary)*:
Date 14/05/14	**Date** 14/5/14	**Date** 14/5/14	**Date**